

Work Order ID 74786 -1

October 6, 2011 1:36:52 PM

74786

Page 1

Item ID: D412-630-033

Revision ID:

Item Name: Heli Access Step LH Folding

Start Date: 10/06/11 Start Qty: 4.00

Required Date: 10/17/11 Req'd Qty: 4.00

Reference:

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Customer:

Approvals: Process Plan: MLJ

QC:

Date: 11/10/08 Tooling:

Date: SPC (Y/N):

Date:

Date:

Run Start *NR1*

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan
Code Accept Reject Reject Insp.
Qty Qty Number Stamp

Draw Nbr Revision Nbr

IIN D412-630 Rev M

100

100

DC

Document Control

DOCUMENT CONTROL

Memo

Photocopy bluefile & create labels per PPP D412-630-033 CHG003

0.00

0.00

110

110

Small Fab

Small Fab

Small Fab

Memo

Assemble as per dwg D412-630 p.14
Coat all hardware with LPS3 rust inhibitor
A/R LPS3 batch: M119317
COAT exposed HARDWARE WITH LPS PROCYON.
A/R LPS PROCYON BATCH: M114596

0.00

0.00

MLJ 11-12-1

11/11/30 (4)

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Item ID: D412-630-033

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Heli Access Step LH Folding

Start Date: 10/06/11 Start Qty: 4.00

4

Cust Item ID:

Required Date: 10/17/11 Req'd Qty: 4.00

4

Customer:

Reference:

Run Start

NR1

Approvals: Process Plan:

Date:

Tooling:

Date:

Stop

NR2

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC5- Inspect part completeness to step on W/O

0.00

120

QC

Memo

0.00

5 4/12/09

+4
6/1

Quality Control

130

Pick Kit

0.00

130

Packaging

Memo

0.00

SP 11-11-29

Packaging

140

QC4- 100% Inspect kits for completeness

0.00

140

QC

Memo

0.00

5 4/12/13

+3
LM

Quality Control

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Item ID: D412-630-033

Accept

N900040100Setup Start ***NS1***Stop ***NS2***

Revision ID:

Item Name: Heli Access Step LH Folding

Start Date: 10/06/11 Start Qty: 4.00

4

Cust Item ID:

Required Date: 10/17/11 Req'd Qty: 4.00

4

Customer:

Reference:

Run Start ***NR1***Stop ***NR2***

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

150

Packaging

Packaging

Packaging

Memo

Identify and pack for shipping as per PPP D412-630-033

Location:

PPP Rev:

0.00

0.00

11/12/13

34

11/12/14

160

160

QC

Quality Control

QC21- Final Inspection - Work Order Release

Memo

0.00

0.00

R 11-12-14
(3)

Picklist Print

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Work Order ID: 74786

74786

Parent Item: D412-630-033

D412-630-033

Parent Item Name: Heli Access Step LH Folding

Start Date: 10/06/11

Required Date: 10/17/11

Start Qty: 4.00

Required Qty: 4.00

NAS1515H3

Purchased

No

110

Each

115.0000

4

16

NAS1515H3

Washer

**

SP

Location

Loc Qty

Loc Code

ST277

115

116373

6

118078

6

118384

103

110

Each

128.0000

4

16

NAS1515H5L

Purchased

No

***NAS1515H5L ***

WASHER

**

16x

M 119309 SP.2x

Location

Loc Qty

Loc Code

FG

40

103691

40

ST277

88

111359

4

118614

84

110

Each

171.0000

4

16

NAS1515H8

Purchased

No

NAS1515H8

Washer

**

118614 14x

SP 11-11-29

Location

Loc Qty

Loc Code

ST278

171

111275

4

111411

167

16x

Picklist Print

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Work Order ID: 74786

74786

Parent Item: D412-630-033

D412-630-033

Parent Item Name: Heli Access Step LH Folding

Start Date: 10/06/11

Required Date: 10/17/11

Start Qty: 4.00

Required Qty: 4.00

MS21043-3

Purchased

No

110

Each

951.0000

4

16

MS21043-3

Nut

**

SP

Location

Loc Qty

Loc Code

FG

72

103691

72

ST301

879

118077

1

118614

492

118686

386

make 110

Each

63.0000

2

8

MS24693-C280

Purchased

No

MS24693-C280

Screw

**

SP 11-11-29

Location

Loc Qty

Loc Code

ST310

62

118093

12

118612

50

ST318

1

111279

1

D2806-1

Manufactured

No

130

Each

18.0000

2

8

D2806-1

Bushing

**

LC 11/14/11

Location

Loc Qty

Loc Code

ST022

18

72141

18

72141 64

Picklist Print

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Work Order ID: 74786

74786

Parent Item: D412-630-033

D412-630-033

Parent Item Name: Heli Access Step LH Folding

Start Date: 10/06/11

Required Date: 10/17/11

Start Qty: 4.00

Required Qty: 4.00

D2806-3

Manufactured No

130

Each

19.0000

2

8

D2806-3

Bushing

**

Location

Loc Qty

Loc Code

ST022

19

70886

1

72138

18

D2810-5

Manufactured No

130

Each

7.0000

1

4

D2810-5

Strut

**

Location

Loc Qty

Loc Code

ST265

7

52034

1

71564

6

D3396-1

Manufactured No

130

Each

12.0000

2

8

D3396-1

Spacer

**

Location

Loc Qty

Loc Code

ST052

12

69906

12

AN4C6A

Purchased

No

130

Each

242.0000

1

4

AN4C6A

Bolt

**

Location

Loc Qty

Loc Code

FG

4

103344

4

ST356

238

116704

15

118451

123

118983

100

11 1:36:57 PM

Order ID: 74786

Parent Item: D412-630-033

Parent Item Name: Heli Access Step LH Folding

74786

D412-630-033

Start Date: 10/06/11

Required Date: 10/17/11

Start Qty: 4.00

Required Qty: 4.00

AN4C10A

Purchased

No

130

Each

60.0000

1 4

**

AN4C10A

Bolt

Location

Loc Qty

Loc Code

ST356

60

112243

30

114523

30

130

Each

65.0000

2 8

**

AN5C15A

Purchased

No

AN5C15A

Bolt

Location

Loc Qty

Loc Code

ST338

15

118191

15

ST339

50

118267

50

130

Each

52.0000

1 4

**

AN44C7A

Purchased

No

AN44C7A

Eyebolt

Location

Loc Qty

Loc Code

ST362

52

109013

12

111308

40

130

Each

129.0000

2 8

**

AN4C15A

Purchased

No

AN4C15A

Bolt

Location

Loc Qty

Loc Code

ST358

129

115835

2

118628

27

118706

100

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Shop Packet Print

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1:36:57 PM

Order ID: 74786

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Parent Item: D412-630-033

D412-630-033

Parent Item Name: Heli Access Step LH Folding

Start Date: 10/06/11

Required Date: 10/17/11

Start Qty: 4.00

Required Qty: 4.00

NAS1515H4

Purchased

No

130

Each

183.0000

7

28

**

NAS1515H4

Washer

LocationLoc QtyLoc Code

ST277

183

116169

3

117460

29

117735

3

118078

48

118612

100

NAS1515H5

Purchased

No

130

Each

163.0000

7

28

**

NAS1515H5

Washer

LocationLoc QtyLoc Code

FG

40

103286

20

103691

20

ST277

123

103286

100

118384

23

MS21043-4

Purchased

No

130

Each

841.0000

4

16

**

MS21043-4

LocationLoc QtyLoc Code

FG

40

104603

40

ST301

801

117793

301

118686

500

Picklist Print

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Parent Item: D412-630-033

Parent Item Name: Heli Access Step LH Folding

74786

D412-630-033

Start Date: 10/06/11

Required Date: 10/17/11

Start Qty: 4.00

Required Qty: 4.00

MS21043-5

Purchased

No

130

Sac

Each

424.0000

3

12

**

Cup/2/9 (Y)

MS21043-5

Nut

LocationLoc QtyLoc Code

FG

20

101418

20

ST301

304

112314

204

116548

100

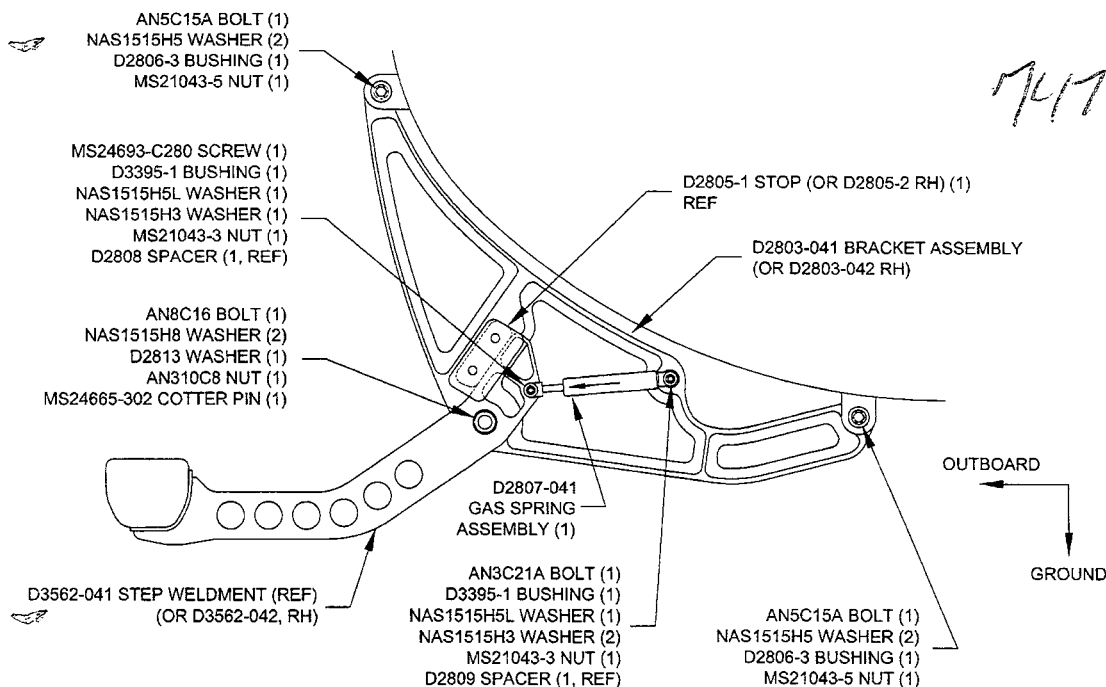
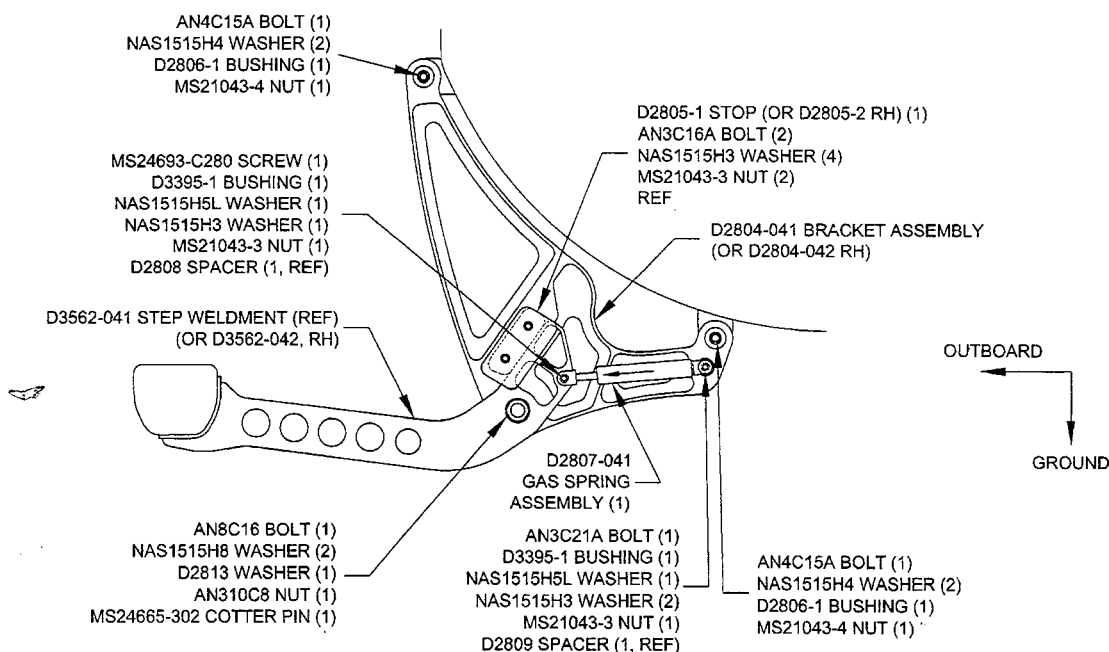
ST314

100

118159

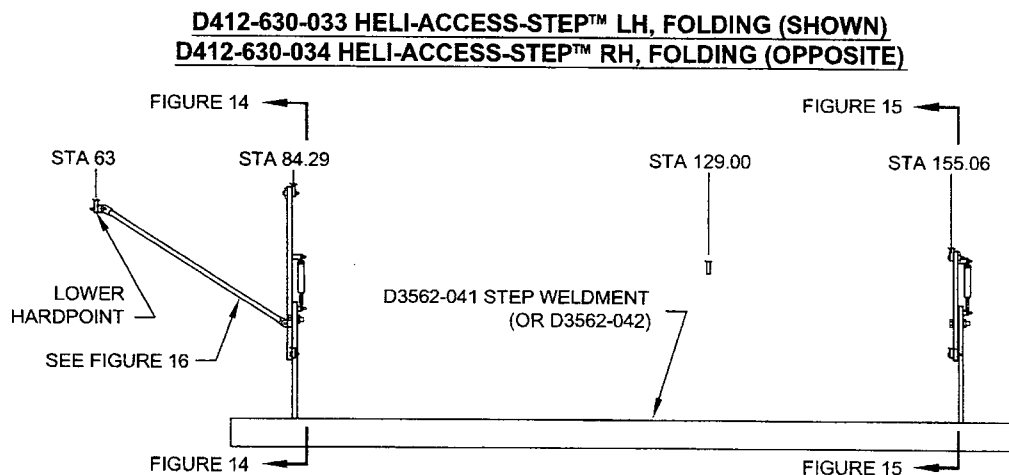
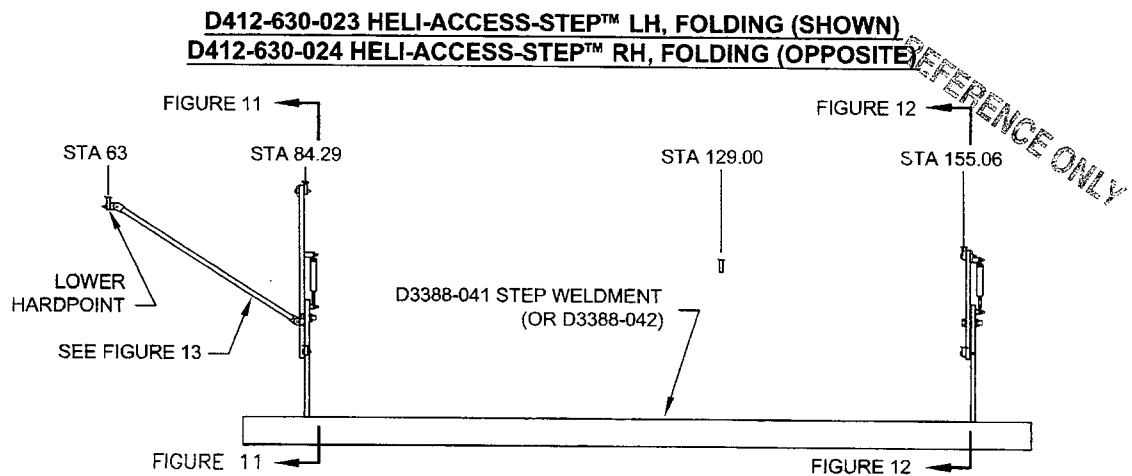
100

112314

D412-630-033/-034 Heli-Access-Step™ Installation**FIGURE 14 – STA 84.29 for D412-630-033/-034 Heli-Access-Step™ Installation
(View rotated 90° CW)****FIGURE 15 – STA 155.06 for D412-630-033/-034 Heli-Access-Step™ Installation
(View rotated 90° CW)**

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Revision: **M**
Date: 08.12.12



D412-630-111 HELI-ACCESS-STEP™ LH, HEAVY DUTY FIXED (SHOWN)
D412-630-112 HELI-ACCESS-STEP™ RH, HEAVY DUTY FIXED (OPPOSITE)

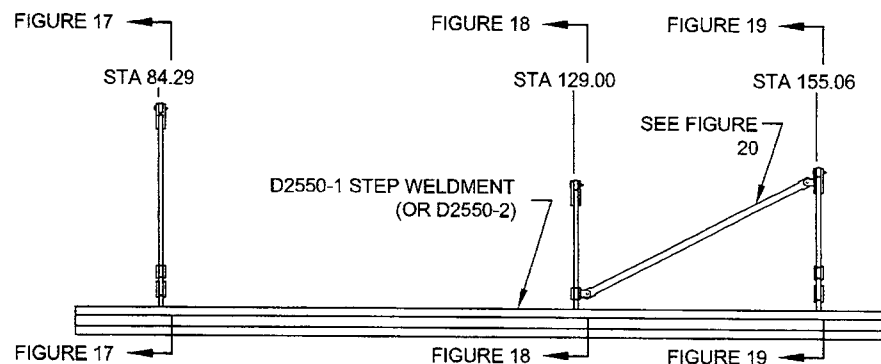


FIGURE 3 – D412-630 Heli-Access-Step™ Installations

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Revision: **M**
 Date: 08.12.12

Qty -033	Qty -034	Qty -243	Qty -244	Part Number	Description
X				D412-630-033	HELI-ACCESS-STEP™ LH (FOLDING)
	X			D412-630-034	HELI-ACCESS-STEP™ RH (FOLDING)
1		X		D412-630-243	STEP ASSEMBLY LH
	1		X	D412-630-244	STEP ASSEMBLY RH
		1	1	D2012-107	CLEVIS
		1		D2803-041	STA 84 BRACKET ASSEMBLY LH
			1	D2803-042	STA 84 BRACKET ASSEMBLY RH
		1		D2804-041	STA 155 BRACKET ASSEMBLY LH
			1	D2804-042	STA 155 BRACKET ASSEMBLY RH
2	2			D2806-1	BUSHING
2	2			D2806-3	BUSHING
		2	2	D2807-041	GAS SPRING ASSEMBLY (WAS D2807)
1	1			D2810-5	STRUT
		2	2	D2813	WASHER
		1		D3562-041	STEP WELDMENT LH
			1	D3562-042	STEP WELDMENT RH
		4	4	D3395-1	BUSHING
2	2			D3396-1	SPACER
		2	2	AN3C21A	BOLT
1	1			AN4C6A	BOLT
1	1			AN4C10A	BOLT
2	2			AN4C15A	BOLT
1	1			AN44-C7A	EYEBOLT
2	2			AN5C15A	BOLT
		2	2	AN8C16	BOLT
		2	2	AN310C8	NUT
		2	2	MS24665-302	COTTER PIN (OR AN380C3-4)
		6	6	NAS1515H3	WASHER
7	7			NAS1515H4	WASHER
7	7			NAS1515H5	WASHER
		4	4	NAS1515H5L	WASHER
		4	4	NAS1515H8	WASHER
		4	4	MS21043-3	NUT
4	4			MS21043-4	NUT
3	3			MS21043-5	NUT
		2	2	MS24693-C280	SCREW (OR MS24694-C565)